

Work Order ID 70062

Tuesday, June 28, 2011 1:39:27 PM



Page 1

Item ID: D3562-042

Accept



Setup Start



Revision ID:

Item Name: Step Assembly, RH

Stop



Start Date: 5/26/2011 Start Qty: 400

Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 400

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3562

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622 extrusion as per Dwg D3562
2-Deburr and bevel ends for welding

Handwritten signature

11.07.06

2 8

110

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

CP 11.07.06

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

11.07.06

2 0

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Item ID: D3562-042

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Setup Start



Revision ID:

Stop



Item Name: Step Assembly, RH

Start Date: 5/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SB 11/07/07

2

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- Drill Rivet holes as per dwg D3562. Touch up alodine

2- Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398 Batch: 117870

11.07.07

2

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/07/07

2

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Start Date: 5/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/RAluminum Rod M114703

2-Grind end cap welds flush as per Dwg D3562

11-07-08 2 0
11-07-11 2 0

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S. W. 11/4

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. W. 11/4

2

042

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Stop



Item Name: Step Assembly, RH

Start Date: 5/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 RH 6 M 11/07/11

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

W 117745.

8:45

320

9:15.

2 6, 11-4-18.

210

Wing Walk as per dwg QSI005 4.4 Batch M 117867

0.00



HandFinish

Memo

0.00

Hand Finishing

2 RH M 11-4-18

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Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, RH

Start Date: 5/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ES 11/07/19 (2)

230

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

w/o
70593

ES 11/07/19 (2)

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/20 JF
MF
11-07-19

Picklist Print

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Page 1

Work Order ID: 70062

Parent Item: D3562-042

Parent Item Name: Step Assembly, RH

Start Date: 5/26/2011

Required Date: 6/6/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

100

Each

145.7000

1



Step Extrusion

Location

Loc Qty

Loc Code

HALL

132

64409

6

68293

126

WA

13.7

46910

2

66970

11.7

4
11.07.06

2 WA 68293 (X2)

D2734

Manufactured

No

140

Each

83.0000

2

8



Step End Plate

Location

Loc Qty

Loc Code

WA

83

69537

8

70701

75

11.07.08

D3560-042

Manufactured

No

140

Each

3.0000

1

4



Arm Weldment

Location

Loc Qty

Loc Code

WA

2

69621

2

WA013

1

48386

1

11.07.07

2

Picklist Print

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Page 2

Work Order ID: 70062

Parent Item: D3562-042

Parent Item Name: Step Assembly, RH



Start Date: 5/26/2011

Required Date: 6/6/2011

Start Qty: 4.00

Required Qty: 4.00

D3560-044

Manufactured No

140 Each

5.0000

1

4



Arm Weldment



11.07.07

Location

Loc Qty

Loc Code

WA

5

69617

5

MS20600-AD4W5

Purchased

No

160 Each

623.0000

32

128



Blind Rivet



11.07.07

Location

Loc Qty

Loc Code

ST321

617

114382

173

117505

200

117739

200

117885

44

WA018

6

111477

6

64

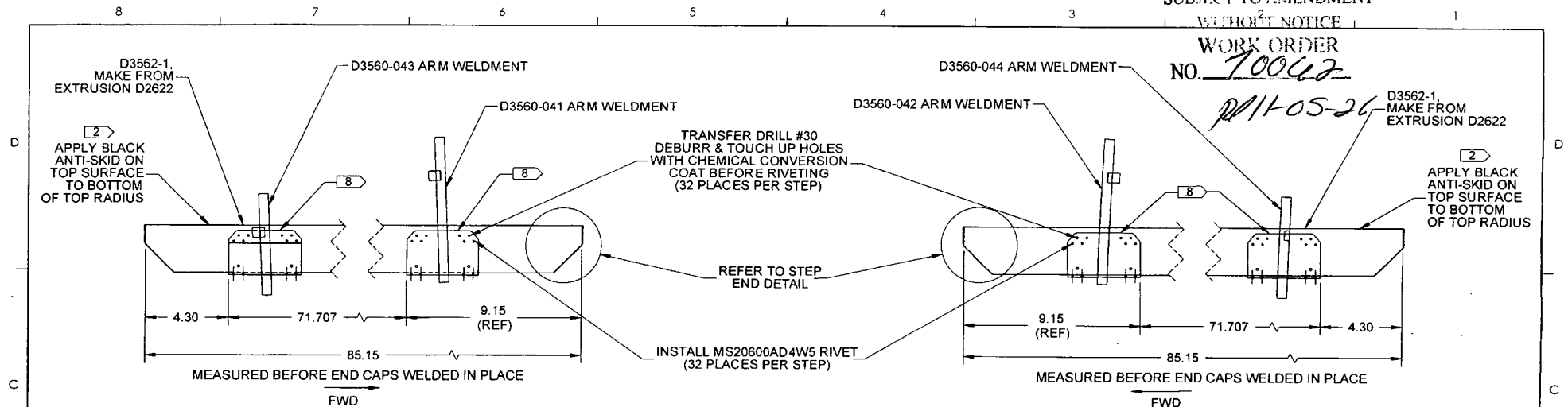
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Shop Packet Print

Page 2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 70062
PA11-05-26



D3562-041 LH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A

2) FINISH:

i) CHEMICAL CONVERSION COAT STEP EXTRUSION
PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
GREY SANDTEX (4.3.5.6) OR
BLACK SANDTEX (4.3.5.7) OR
GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

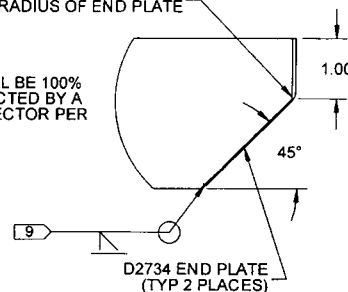
7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN
THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH
MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) WELDING: PER DART QSI 004

NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
SCALE 1:2

D3562-042 RH STEP ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
1	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV	DESCRIPTION	BY	DATE
DESIGN	gp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	st		
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.		D3562	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STEP ASSEMBLY	1:5
DATE	08.01.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PA: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries